

Work Order ID 76923

76923

Page 1

Wednesday, November 23, 2011 3:37:00 PM

Item ID: D205-634-041

Revision ID:

Item Name: Replacement Skidtube

Start Date: 11/23/2011 Start Qty: 1.00

Required Date: 12/9/2011 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580-041	Rev.E

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

110

0.00

110

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

N/A

SAD 12-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76923

Wednesday, November 23, 2011 3:37:00 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 1/23/2011 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 12/9/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

0.00

Skidtubes

Skidtubes

Memo

1- Deburr ends and remove bending marks

2- Prepare tube for welding as per QSI 004

130

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

130

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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Required Date: 12/9/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod *M119712*

2-Grind welds on step as per Dwg D2580

~~3-Weld spacers as per dwg D2580~~ *N/A*3- ~~***N/A***~~ Insert D4202-1 spacer, swage as per QSI002 and trim/ grind
flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2
x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

*BE 12/02/07**MB2/B 12/02/07**[Signature]**12-02-07*

W/O:		WORK ORDER CHANGES					
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Stop ***NS2***

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1

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Required Date: 12/9/2011 Req'd Qty: 1.00

1

Customer:

Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC10- Inspect visual per QSI004- ground welds

0.00

150

QC

Memo

0.00

Quality Control

S 12/02/08

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

S 12/02/08

170

Pressure Wash per QSI005 4.3

0.00

170

HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 p M 12/02/08

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Reference:

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 11:50	0.00							
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 12:20								
190	QC3- Inspect Part Finish	0.00							
190									
QC									
Quality Control	Memo	0.00							

1X Ø M-L 12/02/09

1 Ø M-L 12/02/13

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
200									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 <u>11119 508</u> Sikaflex expire date: <u>12108</u>								
	2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580								
	3-Inspect for foreign object per QSI 024								
	4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 <u>11119 508</u> Sikaflex expire date: <u>12108</u>								
	5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: <u>11110 125</u>								

1 0 12/02/13

W/O:		WORK ORDER CHANGES					
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Start Date: 11/23/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/9/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220		0.00							
220	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041								
	Location: _____								
	PPP Rev: <u>PPP 78163</u>								
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

Handwritten signature

Handwritten signature and date: 12/02/15

Handwritten signature and date: 12/02/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 76923

76923

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 11/23/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 *D4202-1* Spacer		Manufactured	No			140	Each	492.0000	20	20		12-02-07	

Location

Loc Qty

Loc Code

LG002

492

66929

106

67129

196

67308

1

67430

140

72639

49

D2580-1

Manufactured No

110

Each

12.0000

1

1

D2580-1

205 Skidtube bent detail

**

SAD

12-01-30

Location

Loc Qty

Loc Code

LG

12

72965

1

76174

2

76175

2

76510

2

76511

1

76570

2

76571

2

378701

①

W/O:		WORK ORDER CHANGES					
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Work Order ID: 76923

76923

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 11/23/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2576-3 Manufactured No

140

Each

104.0000

1

1

D2576-3

Step (maching detail)

**

BE 12/22/07

Location

Loc Qty

Loc Code

LG

104

66156

4

70883

50

74136

50

D2855 Manufactured No

200

Each

51.0000

1

1

D2855

Cap

**

B75074 (x1) M 12/02/13

Location

Loc Qty

Loc Code

FP002

49

73347

49

FP007

2

65519

2

AN3-5A Purchased No

200

Each

886.0000

2

2

AN3-5A

Bolt

**

M 12/02/13

Location

Loc Qty

Loc Code

ST350

886

115371

46

117423

340

118626

300

119355

200

AN960JD10L NAS1149D0332L Purchased No

200

Each

0.0000

2

2

***AN960JD10I ***

Washer

**

M119042 (x2) M 12/02/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 11/23/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,455.000

50

50

AI S7-1032-130 ✕

M119084 (x50) M120213

Insert

ALS4-1032-130

Location

Loc Qty

Loc Code

ST281

113

117717

27

118966

86

ST282

1342

119530

1342

AN3C4A

Purchased

No

200

Each

1,675.000

50

50

AN3C4A

M119749 (x50) M120213

BOLT

Location

Loc Qty

Loc Code

ST350

1675

117313

2

117688

5

117872

10

118112

16

118451

2

118838

962

119328

678

AN960C10L

NAS1149C0332

Purchased

No

200

Each

0.0000

50

50

***AN960C10L *** ✕

M120648 (x50) M120213

washer

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Parent Item Name: Replacement Skidtube

Start Date: 11/23/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No

200

Each

21.0000

1

1

D3566-13

Gasket

**

B76947 (x1) MU 12/02/13

Location

Loc Qty

Loc Code

FP

20

73322

20

FP014

1

68341

1

D3566-5 Manufactured No

200

Each

21.0000

1

1

D3566-5

Gasket

**

B76945 (x1) MU 12/02/13

Location

Loc Qty

Loc Code

FP002

21

75069

21

D3566-1 Manufactured No

200

Each

15.0000

2

2

D3566-1

Gasket

**

B77569 (x2) MU 12/02/13

Location

Loc Qty

Loc Code

FP002

13

74518

13

FP015

2

68924

2

D3564-11 Manufactured No

200

Each

12.0000

1

1

D3564-11

Wearshoe

**

B76268 (x1) MU 12/02/13

Location

Loc Qty

Loc Code

FP001

12

74705

12

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Parent Item Name: Replacement Skidtube

Start Date: 11/23/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

27.0000

1

1

D3564-13

Wearshoe

**

B76946 Cx11 MU 12/02/12

Location

Loc Qty

Loc Code

FP001

7

73323

7

FP002

19

75045

19

FP017

1

71594

1

D3564-9

Manufactured No

200

Each

21.0000

1

1

D3564-9

Wearshoe

**

B77613 (x1) MU 12/02/12

Location

Loc Qty

Loc Code

FP

2

73345

2

FP001

14

75071

14

FP019

5

67590

4

69943

1

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Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No

200

Each

35.0000

1

1

D3564-5

Wearshoe

**

B76269 (x1) ul 12/02/12

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

32

74543

10

76269

22

FP019

1

73330

1

D2594-3 Manufactured No

200

Each

592.0000

16

16

D2594-3

O-Ring, 205 Skidtube

**

ul 12/02/13

Location

Loc Qty

Loc Code

FP

394

65518

41

66952

55

73490

298

FP004

198

73490

198

D2594-1 Manufactured No

200

Each

208.0000

16

16

D2594-1

Plug, 205 Skidtube

**

B77035 (x16) ul 12/02/12

Location

Loc Qty

Loc Code

FP

208

73401

30

74442

178

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LIST OF MATERIALS					
ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
1	X			D2580-041	SKIDTUBE ASSEMBLY
2		X		D2580-045	SKIDTUBE ASSEMBLY
3			X	D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7	20	24	25	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2598	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-9	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19			1	D4406-041	WEARPLATE ASSEMBLY
20			1	D4406-043	WEARPLATE ASSEMBLY
21	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50		AN3C4A	BOLT
23	2	2	2	AN3-5A	BOLT
24			8	AN4-45A	BOLT
25	50	50		NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
27			8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

SHOP COPY
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SUBJECT TO AND IN ACCORDANCE
WITH THE SOURCE
WORK ORDER
NO. 10923
1011-11-23

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS: DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#		
DRAWN	RF		
CHECKED	10		
MFG. APPR.	10		
APPROVED	10		
DE APPR.	10		
DATE	11.06.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2580** REV. E
SHEET 1 OF 8
TITLE **205 SKIDTUBE ASSEMBLY** SCALE NTS

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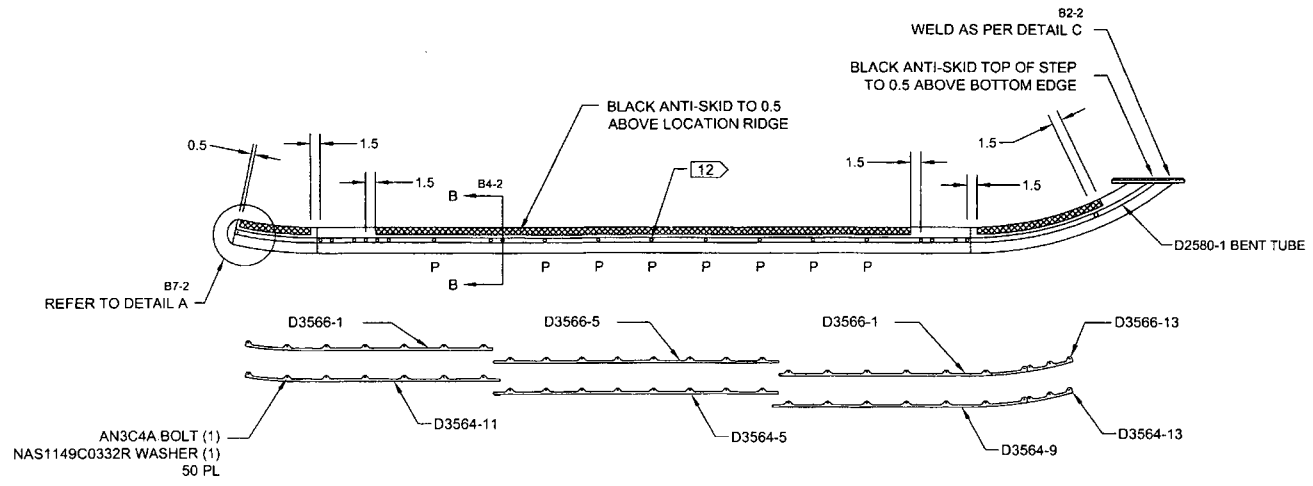
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

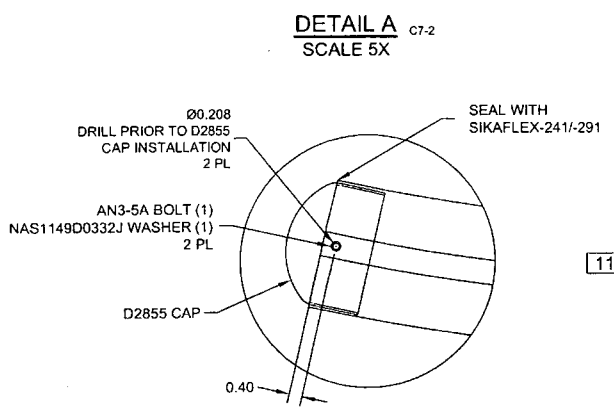
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

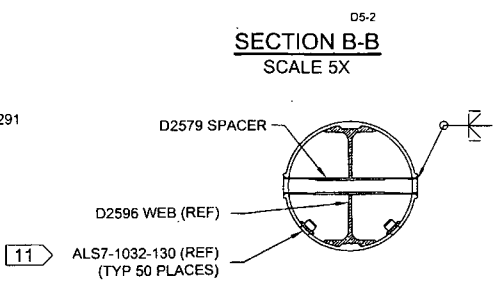
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D2580-041 ASSEMBLY DETAIL

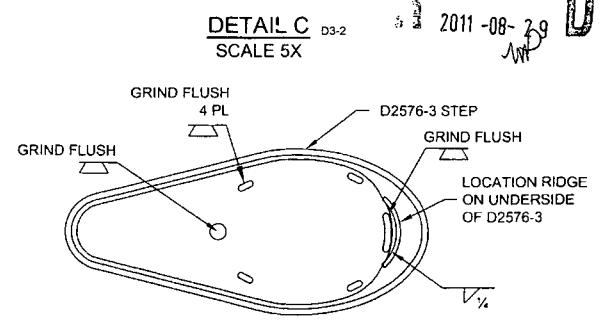


DETAIL A
SCALE 5X








SECTION B-B
SCALE 5X

- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP



DETAIL C
SCALE 5X

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2580	SHEET 2 OF 8
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DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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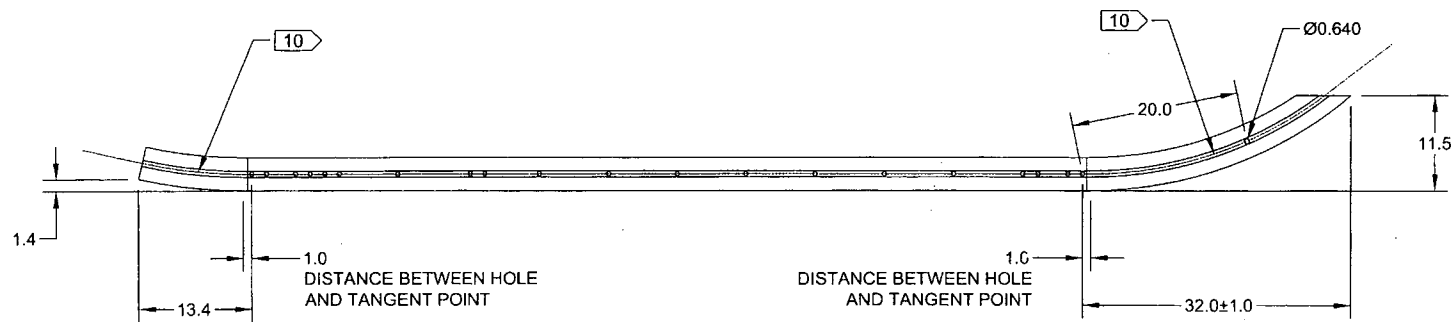
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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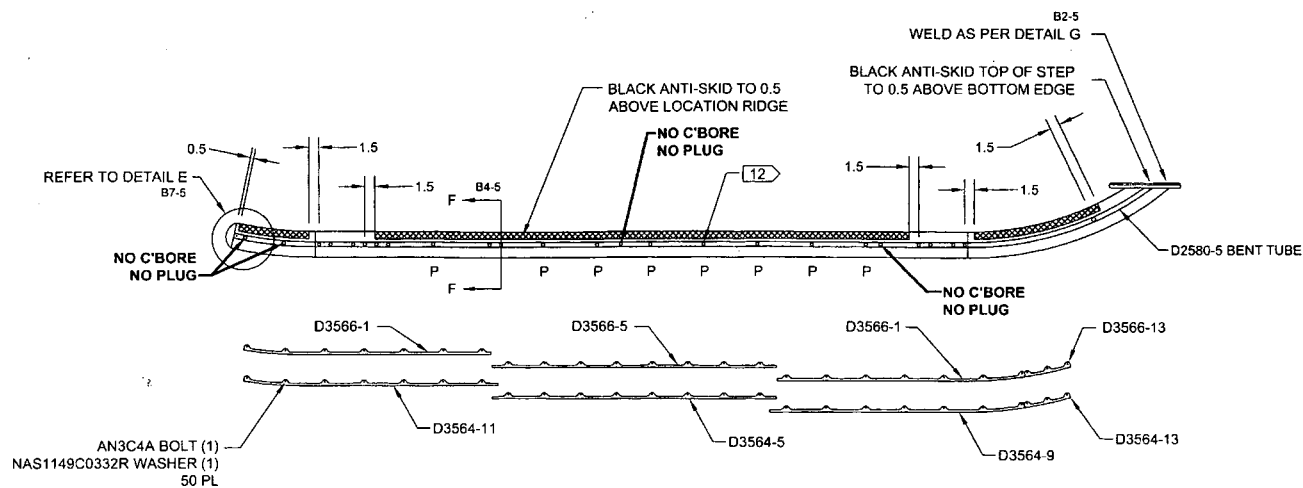
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

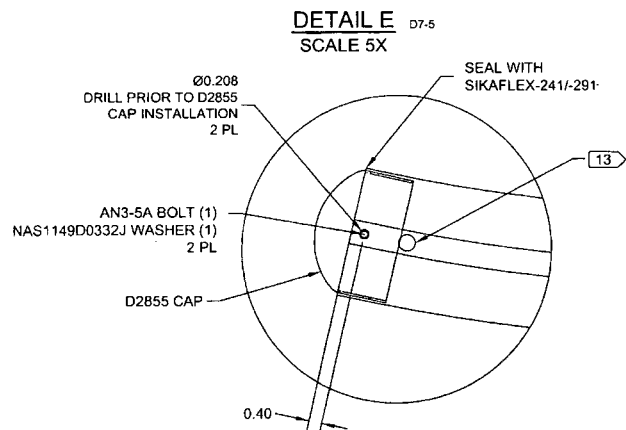
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

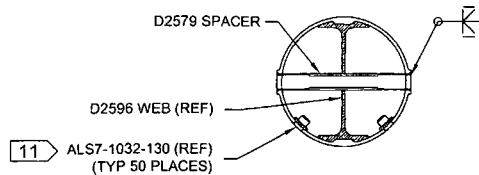
NOTE: Date & initial all entries



D2580-045 ASSEMBLY DETAIL

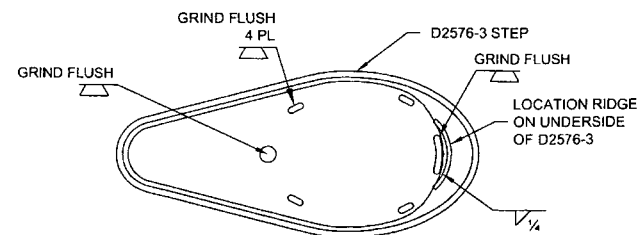


SECTION F-F SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (24 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL G SCALE 5X



74923

DESIGN	4	DART AEROSPACE LTD	
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MFG. APPR.	10	D2580	SHEET 4 OF 8
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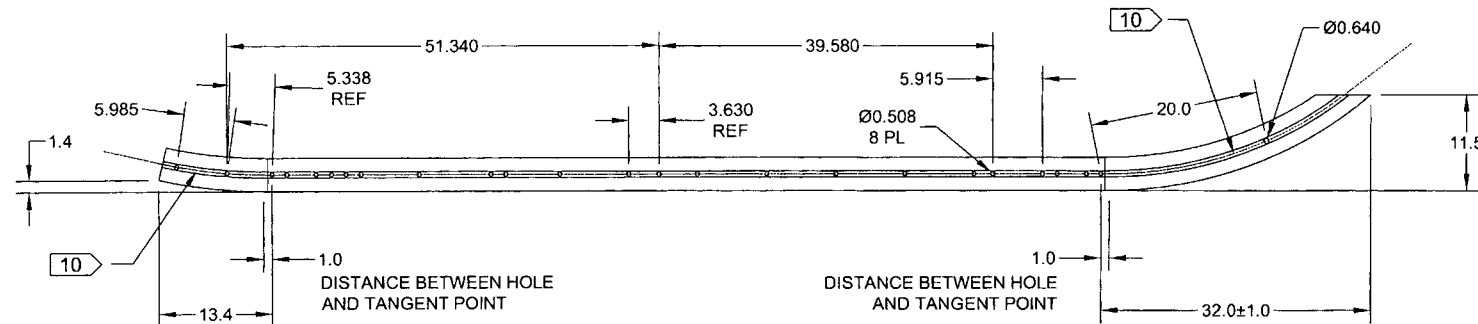
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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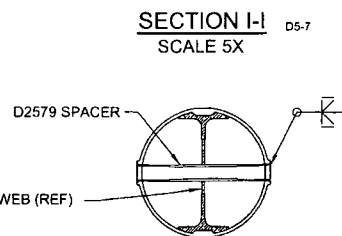
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DETAIL J
D3-7
SCALE 5X

GRIND FLUSH
4 PL

GRIND FLUSH

D2576-3 STEP

GRIND FLUSH

LOCATION RIDGE
ON UNDERSIDE
OF D2576-3

1/4"

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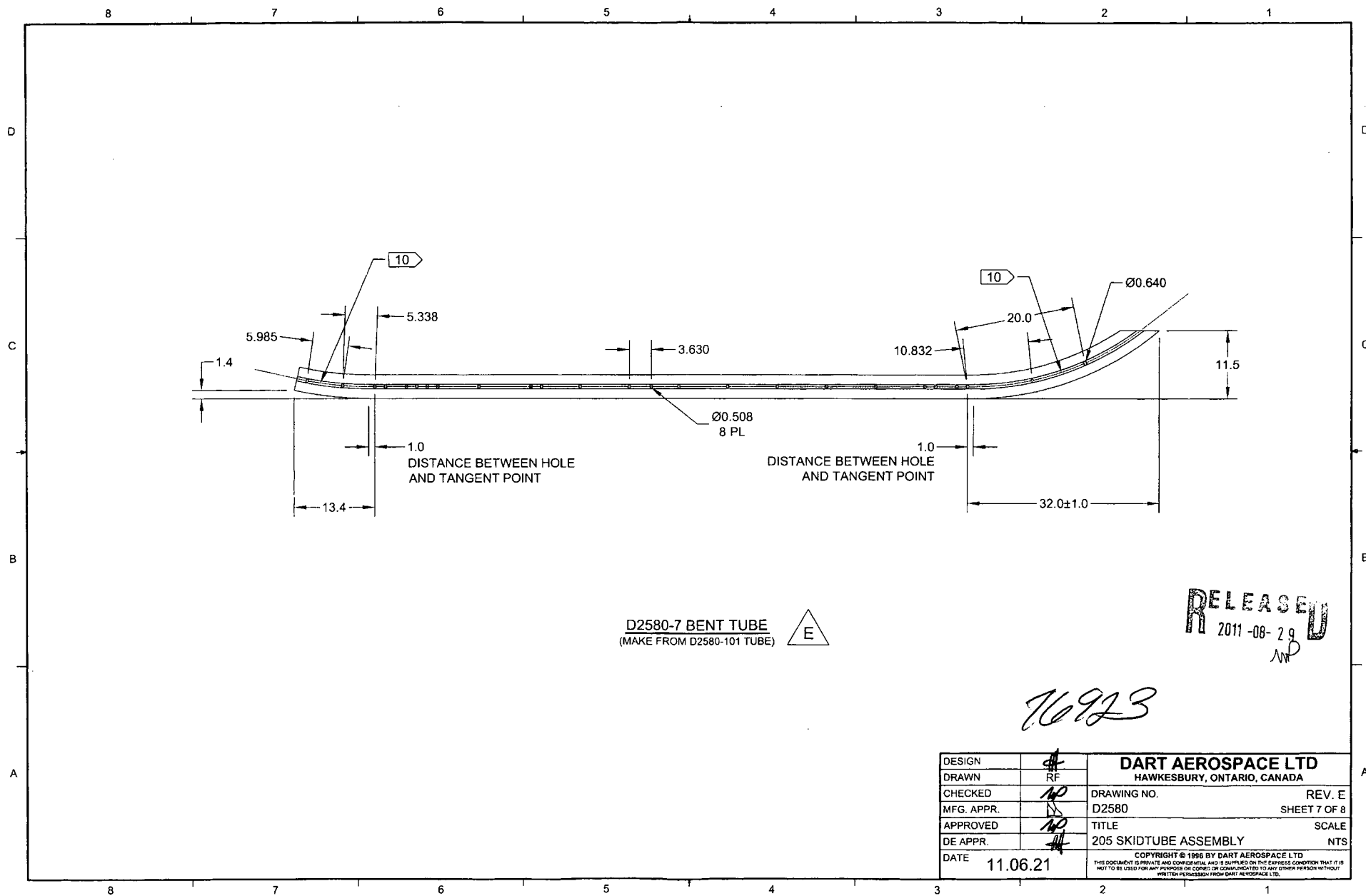
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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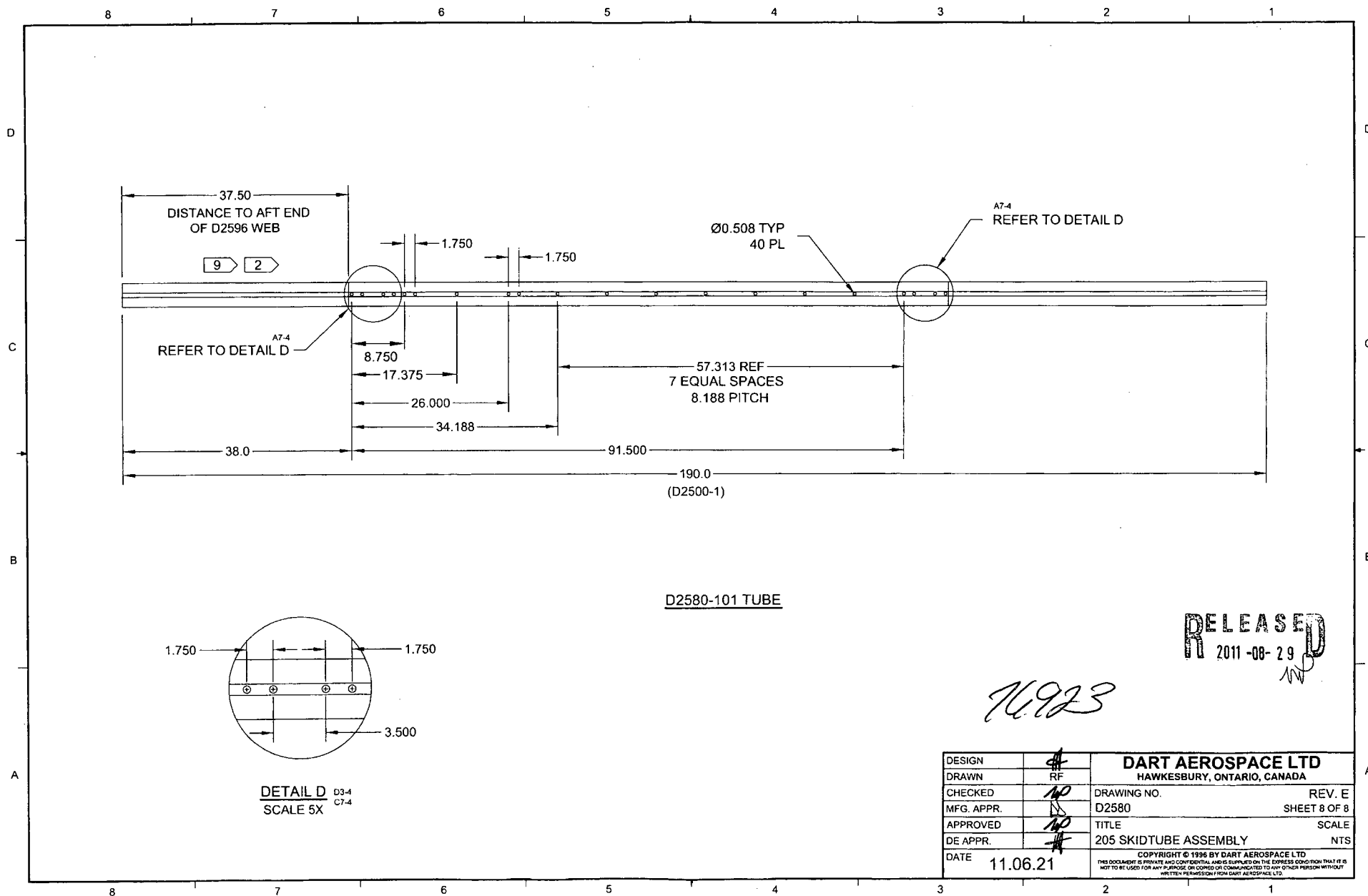
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NOTE: Date & initial all entries